

SHIP TODAY

Work Order ID 58475

May 7, 2010 10:24:34 AM



Item ID: D205-778-011

Accept



Setup Start



Revision ID:

Item Name: Comfort Seat, LH/RH

Stop



Start Date: 07/05/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-5-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9508

A

IIN D205-778

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D205-778-011 CHG 0023 as per
ECN 027002 10/06/02
as per Kim

[Signature] for CL 10/06/02

8.06.02

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-6-2 *[Signature]*

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

5.06662



130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D205-778-101

Location: _____
PPP Rev: _____

10/06/2010 (1)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/03
MF
10-6-02

Picklist Print

May 7, 2010 10:24:40 AM

Page 1

Work Order ID: 58475

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Comments: IPP Rev:A 08-10-20 New Issue DD verified by:EC
per DSI 9508 DD 10.03-24 verified by:EC

IPP Rev:B as

Start Date: 07/05/2010

Required Date: 14/05/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN960JD6L Washer		Purchased	No			110	Each	1,137.000	16			

Location

Loc Qty

Loc Code

ST347

1137

5519

1137

110

Each

184.0000

BSP-42

Purchased

No

Rivet

Location

Loc Qty

Loc Code

ST

184

114598

184

110

Each

1.0000

D3752-1

Manufactured

No

Seat Frame

Location

Loc Qty

Loc Code

ST252A

1

58352

1

110

Each

0.0000

D3755-041

Manufactured

No

Seat Cushion

D3756-041

Manufactured

No

Cushion

Location

Loc Qty

Loc Code

ST252A

2

57908

2

Picklist Print

May 7, 2010 10:24:40 AM

Page 2

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per DSI 9508 DD 10.03-24 verified by:EC





IPP Rev:B as


Start Date: 07/05/2010


Required Date: 14/05/2010


Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
S D3758-041  Clamp		Manufactured	No			110	Each	0.0000	2	1		
D3777-041  Clamp		Manufactured	No			110	Each	20.0000	2	1		
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>		
					ST087			20				
					46659			20				
D3800-3-200  Hook and Loop Strip (2" Hard)		Manufactured	No			110	f	183.7947	2	1		
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>		
					ST089			183.7947				
					43367			108.7947				
					56393			75				
1- Cut to length as per dwg AN525-10R8  Screw		Purchased	No			110	Each	124.0000	8	1		
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>		
					ST325			124				
					111274			24				
					114494			100				

 B58262 10-6-2 SP

 10-6-2 SP

 10-6-2 SP

 10-6-2 SP

 8

→ measure
8.0/6.0/6.0

cut to length 6.0" x 4

4x 6"

Picklist Print

May 7, 2010 10:24:40 AM

Page 3

Work Order ID: 58475



Parent Item: D205-778-011



Parent Item Name: Comfort Seat, LH/RH

Start Date: 07/05/2010

Required Date: 14/05/2010

Comments: IPP Rev:A 08-10-20 New Issue DD verified by:EC
per DSI 9508 DD 10.03-24 verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN970-3 Washers		Purchased	No			110	Each	56.0000	8	16-6-2sf		

Location

Loc Qty

Loc Code

ST349

56

113749

56

AN960JD10

Purchased

No

110

Each

0.0000

Washer

MS21042L3

Purchased

No

100

Each

1,673.000

Nut

Location

Loc Qty

Loc Code

ST300

1673

113537

20

113644

653

114523

1000

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-778 REV. B
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-778 REV. 1

REF TCCA STC: SH08-37

REF FAA STC: SR02704NY

REF EASA STC: EASA.IM.R.S.01518

REFERENCE ONLY

PURPOSE:

To provide instructions to allow the hook strip (ie. velcro) on the D3752-1 Seat Frame to be fastened with rivets.

CHANGE:

D205-778-011 Comfort Seat Kits at CHG 002 have rivets and washers that may be installed to fully secure the D3800-3-200-060 Hook Strip to the D3752-1 Seat Frame. The parts list of Installation Instructions IIN-D205-778 and Instructions for Continued Airworthiness ICA-D205-778 is amended as shown below. Installation of the rivets is optional.

PARTS LIST

QTY -011	Part Number	Description
X	D205-778-011	Comfort Seat Kit
8	BSP-42	Rivet (Add)
16	NAS1149DN616J	Washer (or AN960JD6L) (Add)

INSTALLATION INSTRUCTIONS

Install the BSP-42 rivets as detailed below, see Figure 1 of this service instruction as reference:

- 1) Ensure location of D3800-3-200-060 Hook Strip lines up with loop strip on seat cushions.
- 2) Drill D3752-1 Seat Frame using 9/64" (Ø0.141) drill in appropriate locations: ensure rivet location will not interfere (contact) with the OEM metal seat frame. Deburr hole.
- 3) Install each BSP-42 rivet with qty(2) NAS1149DN616J washers (one on either side of the plastic seat frame). It is acceptable to substitute longer/shorter BSP rivets or thicker NAS1149DN632J washers to ensure proper fit.

UPGRADE KIT

For D205-778-011 Comfort Seat Kits at CHG 001, the DSI-9508-011 Rivet Kit is available from Dart:

QTY -011	Part Number	Description
X	DSI-9508-011	Rivet Kit
8	BSP-42	Rivet
16	NAS1149DN616J	Washer (or AN960JD6L)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.03.02
CERT. NO.: SH08-37
ISSUE NO.: 1

A	NEW ISSUE	CP	10.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	15	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9508	SHEET 1 OF 2
APPROVED	11	TITLE	SCALE
DE APPR.	11	RIVET KIT	NTS
DATE	10.03.02	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-778-011	13.0 lb	±22.0 in	±286 in-lb	47.0 in	611 in-lb
Comfort Seat Kit, LH / RH	5.9 kg	±0.56 m	±3.3 m-kg	1.19 m	7.0 m-kg

5.0 PARTS LIST

Qty	Part Number	Description
X	D205-778-011	COMFORT SEAT KIT (FITS LH & RH)
1	D3752-1	SEAT FRAME
1	D3755-041	CUSHION
1	D3756-041	CUSHION
2	D3758-041	CLAMP ASSEMBLY
*2	D3758-1	CLAMP
*2	D2182B028	RUBBER CUSHION
2	D3777-041	CLAMP ASSEMBLY
*2	D3777-1	CLAMP
*2	D2182B013	RUBBER CUSHION
4	D3800-3-200-060	HOOK STRIP
8	AN525-10R8	SCREW
8	AN970-3	WASHER
8	AN960JD107	WASHER
8	MS21042L3	NUT (OR MS21042-3)

* REFERENCE ONLY. PARTS ARE INCLUDED IN ASSEMBLY ABOVE.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries